

Work Order ID 111102

Thursday, January 09, 2014 11:29:52 AM

Page 1

Item ID: PB67-43001-261

PB67-43001-261 *111102*
B11102

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lever Arm

Stop ***NS2***

Start Date: 1/8/2014 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 14-01-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001	C
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100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

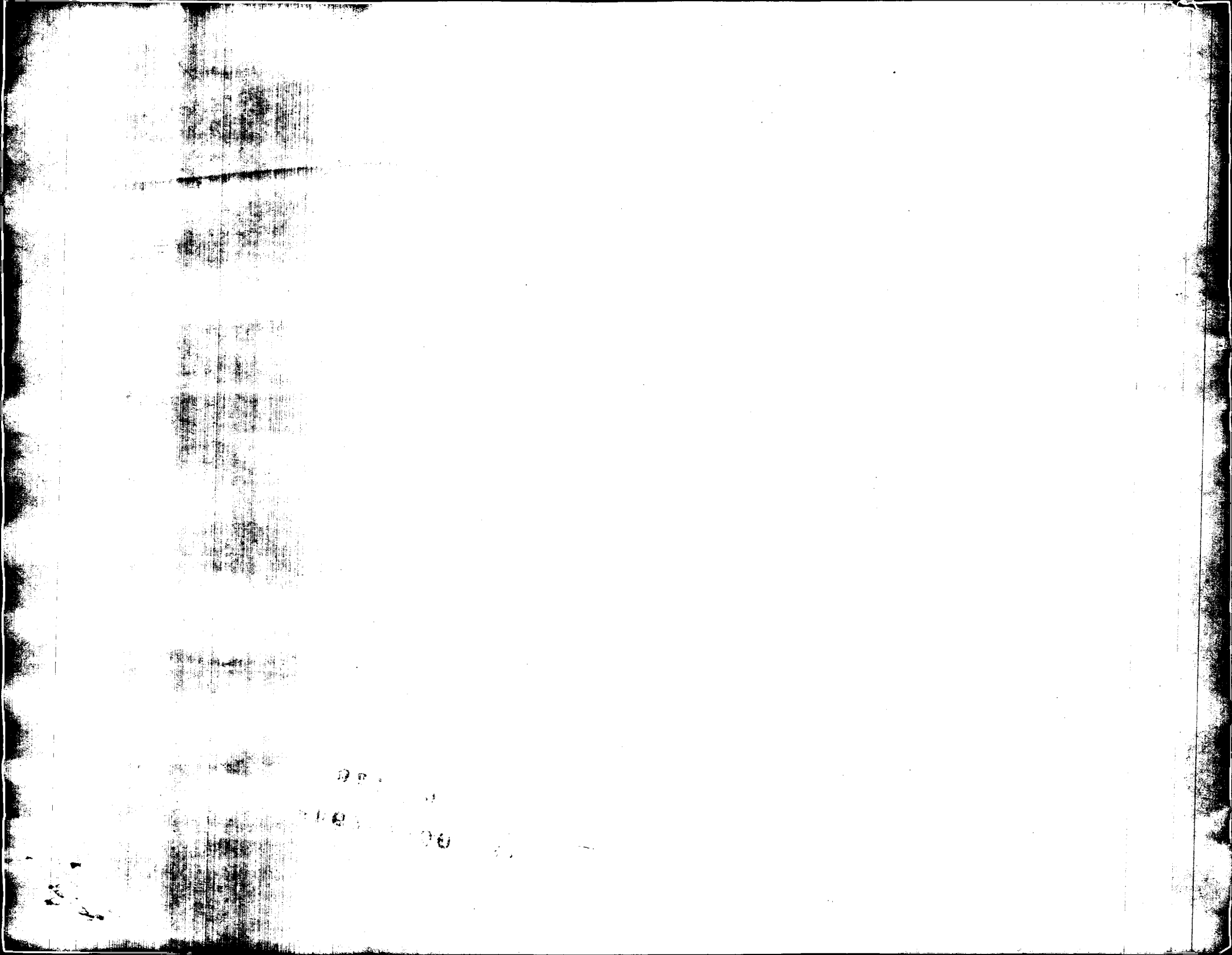
Memo

0.00

Quality Control

24 0 Jm14-02-03

24 0 Jm14-02-3



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Item ID: PB67-43001-261

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lever Arm

Start Date: 1/8/2014 Start Qty: 20.00

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Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 20.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
140	Powdercoat								
Powdercoat	Memo								
Powder Coating									

DAS
27
9-89
M1213

24

24 M 14-2-3

M165008

START TIME: 3:30
OVEN TEMPERATURE: 320°
FINISH TIME: 9:10

24 ~~14-2-5~~ DAS 34 9-89

24 ~~14-2-6~~

Work Order ID 111102

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111102

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Item ID: PB67-43001-261 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lever Arm
 Start Date: 1/8/2014 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				24			
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

14-02-06

Picklist Print

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Work Order ID: 111102

Parent Item: PB67-43001-261

Parent Item Name: Lever Arm

Start Date: 1/8/2014

Required Date: 1/24/2014

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.06.07New issueKJ/JLM
IPP Rev:B 08-06-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.000 6061-T6 Bar .250 x 6.00		Purchased	No			100	f	126.6100	1.388	30			

Location

Loc Qty

Loc Code

MAT051

126.61

121040

0.15

123279

17.86

125386

23.86

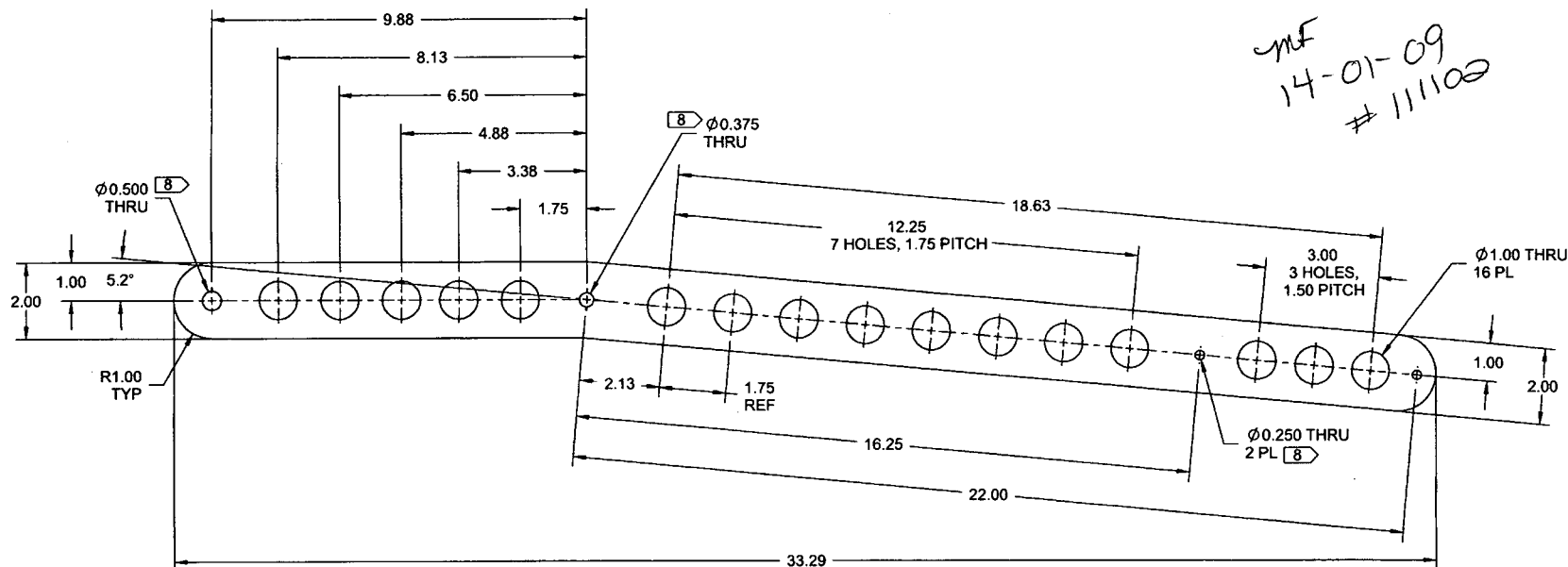
125590

3.74

m126647

81

125024 →



B67-43001-261 LEVER ARM

RELEASED
2009-09-24
WJ

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREEN SANOTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs
- 8) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 39 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.03.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO. B67-43001-261	REV. C	
MFG. APPR.		SHEET 1 OF 1		
APPROVED		TITLE LEVER ARM	SCALE	
DE APPR.	N/A	NTS		
DATE	09.03.11	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD	Work Order: 311102
Description: Lever Arm	Part Number: 2 PB67-43001-261
Inspection Dwg: 867-43001 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.88	+/- .030	9.88"	-		T	Jkm06
8.13	+/- .030	8.139"	-		T	
6.50	+/- .030	6.50"	-		V	Jkm01
4.88	+/- .030	4.88"	-		V	
3.38	+/- .030	3.38"	-		V	
1.75	+/- .030	1.75"	-		V	
1.00	+/- .030	1.00"	-		V	
2.00	+/- .030	2.00"	-		V	
2.13	+/- .030	2.13"	-		V	
1.75	+/- .030	1.75"	-		V	
16.25	+/- .030	16.25"	-		T	
22.00	+/- .030	22.00"	-		T	
12.25	+/- .030	12.25"	-		T	
18.63	+/- .030	18.63"	-		T	
3.00	+/- .030	3.007"	-		V	
33.29	+/- .030	33.29"	-		T	
Ø .375	+0.005/-0.001	0.377"	-		V	
Ø .500	+0.006/-0.001	0.503"	-		V	
Ø 1.00	+0.010/-0.001	1.00"	-		V	
Ø .250	+0.005/-0.001	0.253"	-		V	

Measured by: Jm
Date: 14-02-3

Audited by: DAS 27 9-89
Date: 14/2/3

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15